

CLAIMS

1. A reclosable bag comprising a receptacle, a slider-actuated string zipper at one end of said receptacle, and a flap extending from an opposite end of said receptacle in a direction away from said string zipper, said flap comprising a discontinuity.

5                   2. The bag as recited in claim 1, wherein said receptacle comprises first and second walls that are fused together in a band-shaped zone to form said opposite end of said receptacle, said flap starting at and extending away from said band-shaped zone.

10                   3. The bag as recited in claim 2, wherein said flap is integrally formed with said first wall.

4. The bag as recited in claim 1, wherein said discontinuity is a hole.

5. The bag as recited in claim 1, wherein said discontinuity is a slit.

15                   6. The bag as recited in claim 1, wherein said flap further comprises a line of weakened tear resistance.

7. The bag as recited in claim 6, wherein said line of weakened tear resistance comprises a series of spaced perforations.

20                   8. The bag as recited in claim 6, wherein said line of weakened tear resistance comprises a scoreline.

9. The bag as recited in claim 6, wherein said line of weakened tear resistance extends across a majority of the length of said flap.

10. A reclosable bag comprising:

25                   a receptacle comprising first and second walls comprising respective upper marginal portions that form a mouth at a top of said receptacle

and respective lower portions that extend to a bottom of said receptacle;

a string zipper comprising first and second mutually interlockable zipper strips respectively joined to said upper marginal portions of said first and second walls;

5 a slider mounted on said string zipper for opening and closing said string zipper; and

a flap extending from said bottom of said receptacle in a direction away from said string zipper.

10 11. The bag as recited in claim 10, wherein said bottom of said receptacle comprises a heat seal that joins said first and second walls in a band-shaped zone.

12. The bag as recited in claim 10, wherein said flap is integrally formed with said first wall.

15 13. The bag as recited in claim 10, wherein said flap comprises first and second discontinuities.

14. The bag as recited in claim 10, wherein said flap further comprises a line of weakened tear resistance.

20 15. The bag as recited in claim 10, wherein said slider comprises first and second side walls, said upper marginal portion of said first wall of said receptacle being disposed between said first side wall of said slider and a back of said first zipper strip, and said upper marginal portion of said second wall of said receptacle being disposed between said second side wall of said slider and a back of said second zipper strip.

25 16. A method of manufacturing a reclosable bag, comprising the following steps:

(a) folding a web of bag making film so that a first portion of said web on one side of said fold has an extension portion that extends beyond an edge of a second portion of said folded web;

5 (b) joining a back of a first flangeless zipper strip to one of said first and second web portions before or after said folding step;

(c) joining a back of a second flangeless zipper strip to the other of said first and second web portions before or after said folding step;

10 (d) joining confronting portions of said first and second web portions along a band-shaped zone extending generally parallel to and proximal to said edge of said second portion of said folded web;

(e) removing the folded edge of said web; and

(f) inserting a slider on said first and second flangeless zipper strips after the folded edge has been removed.

15 17. The method as recited in claim 16, wherein said removing step comprises cutting respective portions of said first and second web portions adjacent said string zipper.

18. The method as recited in claim 16, further comprising the step of forming first and second discontinuities in said extension portion of said web before or after said folding step.

20 19. The method as recited in claim 18, wherein said discontinuities are holes.

20. The method as recited in claim 18, wherein said discontinuities are slits.

25 21. The method as recited in claim 16, wherein step (a) is performed after step (b) and before step (c), further comprising the step of interlocking said first and second flangeless zipper strips prior to step (b).

22. The method as recited in claim 16, wherein steps (b) and (c) are performed after step (a), further comprising the step of interlocking said first and second flangeless zipper strips and inserting said interlocked first and second flangeless zipper strips between said first and second web portions prior to steps (b) and (c).

23. The method as recited in claim 16, wherein steps (b) and (c) are performed before step (a), further comprising the step of interlocking said first and second flangeless zipper strips after step (a).

24. A reclosable bag comprising:

first and second generally rectangular walls, each of said first and second walls having a top, a bottom and two sides, said first and second walls having the same width from side to side, but different heights from top to bottom, the tops of said first and second walls being generally aligned, while said second wall extends beyond the bottom of said first wall to form a flap, said first and second walls being joined together along a band-shaped zone proximal to the bottom of said first wall;

first and second flangeless zipper strips having backs respectively joined to respective portions of said first and second walls that are proximal to their respective tops; and

a slider mounted on said first and second flangeless zipper strips and movable in opposite directions for causing said first and second flangeless zipper strips to engage or disengage.

25. The bag as recited in claim 24, wherein said first and second walls comprise thermoplastic material that is fused together in said zone of joiner.

26. The bag as recited in claim 24, wherein said flap comprises first and second discontinuities.

27. The bag as recited in claim 26, wherein said discontinuities are holes.

28. The bag as recited in claim 26, wherein said discontinuities are slits.

5                   29. The bag as recited in claim 24, wherein said flap further comprises a line of weakened tear resistance.

30. The bag as recited in claim 29, wherein said line of weakened tear resistance comprises a series of spaced perforations.

10                   31. The bag as recited in claim 29, wherein said line of weakened tear resistance comprises a scoreline.

32. A method of manufacturing a reclosable bag, comprising the following steps:

15                   (a) arranging and sealing film material to form a receptacle and a flap connected to said receptacle, said receptacle having an interior volume and a mouth for accessing said interior volume, and said flap extending beyond a boundary of said receptacle located opposite to and distant from said mouth;

                    (b) prior to completion of said receptacle, joining respective portions of said film material, that will form said mouth of said receptacle, to respective backs of first and second flangeless zipper strips;

20                   (c) aligning said first and second flangeless zipper strips with each other; and

                    (d) after steps (b) and (c), mounting a slider onto said aligned first and second flangeless zipper strips with said respective portions of said film material being disposed between respective side walls of said slider and  
25                   respective backs of said first and second flangeless zipper strips.

33. The method as recited in claim 32, wherein step (a) comprises the following steps:

folding a web of film material along a fold line to form a U- or V-shaped profile comprising first and second legs;

5 joining respective portions of said first and second legs of said web to form said receptacle, other respective portions of said first and second legs forming said respective opposing portions joined to said string zipper.

34. The method as recited in claim 33, wherein said first and second legs are band-sealed together along a line parallel to and spaced apart  
10 from said fold line.

35. The method as recited in claim 33, wherein said second leg is longer than said first leg, said flap comprising a portion of said second leg that extends beyond an edge of said first leg.

36. The method as recited in claim 33, further comprising the step  
15 of trimming respective portions of said first and second legs connected by said fold line.

37. The method as recited in claim 33, further comprising the step of forming at least one discontinuity in said flap.

38. The method as recited in claim 33, further comprising the step  
20 of forming a line of weakened tear resistance in said flap.